



Dart Aerospace Ltd.
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Canada

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D3319-3
Job Sheet 196910-A



Part No: D3319-3

Job Qty: 6 pcs

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/19

Job Tracking No:

Due Date: 7/20/19

Created By: Eric Larocque

Type: Stock

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
150	QC 5	6 pcs	7/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
160	Automated Welding - B4B	6 pcs	7/20/19		0.00	1.91	Automated Welding - 1 - B4B		<i>ML</i>
170	QC 10	6 pcs	7/20/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		<i>R</i>
							QC 10 - 58		
							QC 10 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		



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Container No: S198674



Part: D3319-3

Job No: 196910-A

Serial No/Batch: S196893

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/17/19

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	2
					QC 5 - 30	
					QC 5 - 40	
190	Spray Paint - 2 - B4B	6	7/20/19	0.00 0.60	Spray Paint - 1 - B4B	AB 9-7-18
	pcs				Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200	QC 3	6	7/20/19	0.00 0.00	QC 3 - 10	
	pcs				QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	DAS
					QC 3 - 9	40
					QC 3 - 40	11/19/2019 9-89
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210	Packaging 3-1 - Stock - B4B	6	7/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	6	7/20/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 150 - (QC5- Inspect part completeness to step on W/O)
 Descriptions: 160 - 8259 Hardcoat Rod _____
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
 BATCH: 5184717
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location: _____) Identify on inside surface using a permanent fine point marker with the following:
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499		
3	Wearplate	0.316inches ± 0.010	0.326 0.306		
4	Wearplate	0.607inches ± 0.010	0.617 0.597		
5	Wearplate	2.940inches ± 0.030	2.970 2.910		
6	Wearplate	2.690inches ± 0.030	2.720 2.660		
7	Wearplate	3.527inches ± 0.010	3.537 3.517		
8	Wearplate	4.520inches ± 0.030	4.550 4.490		
9	Wearplate	5.063inches ± 0.010	5.073 5.053		
10	Wearplate	6.160inches ± 0.030	6.190 6.130		
11	Wearplate	0.600inches ± 0.030	0.630 0.570		
12	Wearplate	8.690inches ± 0.010	8.700 8.680		
13	Wearplate	30.790inches ± 0.010	30.800 30.780		
14	Wearplate	52.880inches ± 0.030	52.910		

			52.850
15	Wearplate	62.770inches $\pm$ 0.010	62.780 62.760
16	Wearplate	74.420inches $\pm$ 0.010	74.430 74.410
17	Wearplate	75.520inches $\pm$ 0.030	75.550 75.490
18	Wearplate	0.050inches $\pm$ 0.010	0.060 0.040

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